

**Amendments to the Claims:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

1. (Currently Amended) A method for manufacturing a pleated filter material from a thermally bonded non woven fabric, comprising :

- forming a single fibrous web from undrawn and drawn synthetic fibers;
- pre-heating the fibrous web;
- calendering the single fibrous web between non-heated profiled calender rolls in a single calendering step without subsequent re-heating, wherein during the single calendering step, the undrawn fibers in the single fibrous web are bonded in a tension free manner between the non-heated profiled calender rolls to form the non woven fabric, wherein no portion of the non woven fabric is bonded more strongly over its cross-section than the remainder of the non woven fabric such that the non woven fabric is formed without inhomogeneities over the cross section of the non woven fabric and without the use of flat bonding, and wherein during the single calendering step, spacers are formed in the non woven fabric to thereby form the filter material.